

Date: Monday, 6/19/2006 11:31:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FOOT
 Job Number : 27652
 Estimate Number : 11245
 P.O. Number : N/A
 This Issue : 6/19/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 27422
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *KJ 06.06.19*
 Comment : Est. A 05.05.19 New issue KJ/JLM

Part Number : D34371
 Drawing Number : D3437 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 7/8/2006 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R1000 ROUND BAR 1.00"



Comment: Qty.: 0.5424 f(s)/Unit Total: 3.2546 f(s)
 ROUND BAR 1.00"
 Material: 6061-T6 Round Bar Ø1.00" (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6R1.000)
 Identify for D3437-1
 Batch: M1847 72" Dwg Rev. B 12

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Turn as per Dwg D3437

M8 06/06/24 12

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA527 and Dwg D3437
 Folio Rev: _____ Dwg Rev. _____
 Deburr

} done manually

M8 06/06/24 12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/06/24 12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 06/06/25 x 17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 06/06/27

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:31:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOOT

Job Number: 27652

Part Number: D34371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-06-27

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask threaded hole

a.m 06-06-27

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

///

06 06 27

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5435*

06/06/27

(12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/27

(12)

Job Completion



U 06-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

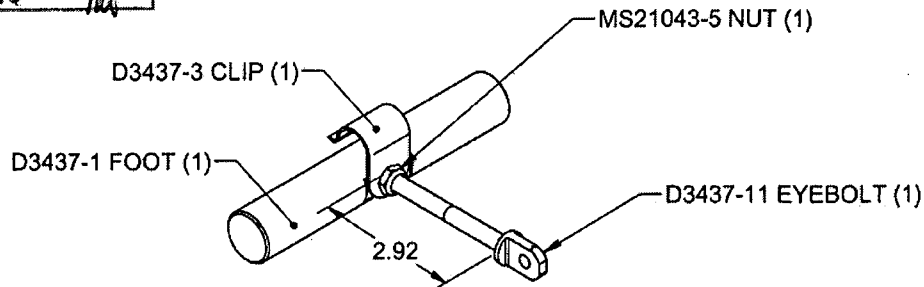
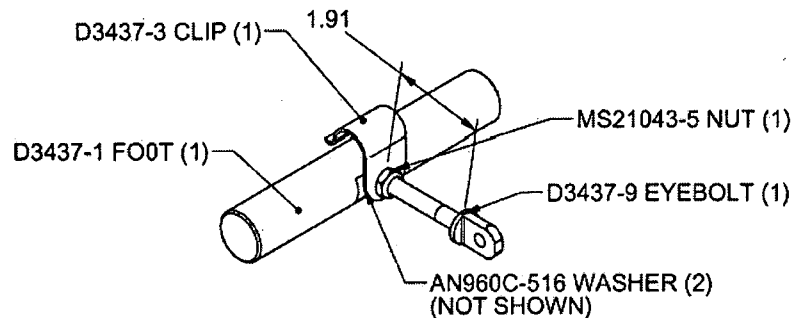
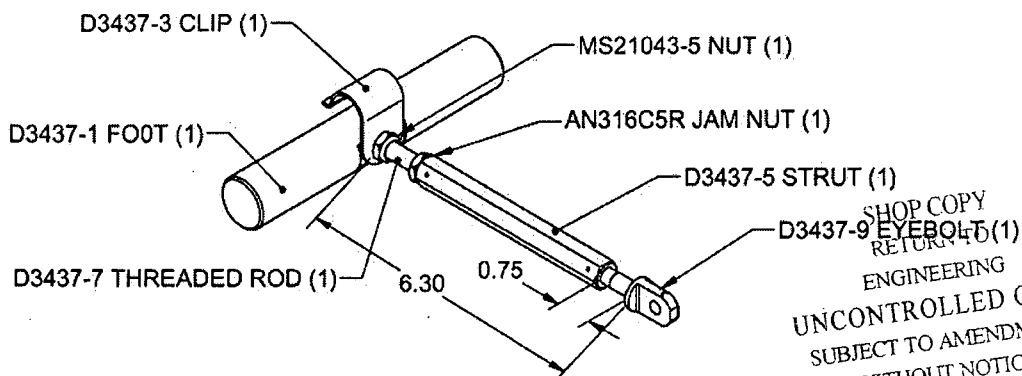
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 1 OF 4
DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED05.08.16 *[Signature]***D3437-041 AFT STRUT ASSEMBLY****D3437-043 AFT STRUT ASSEMBLY****D3437-045 AFT STRUT ASSEMBLY**

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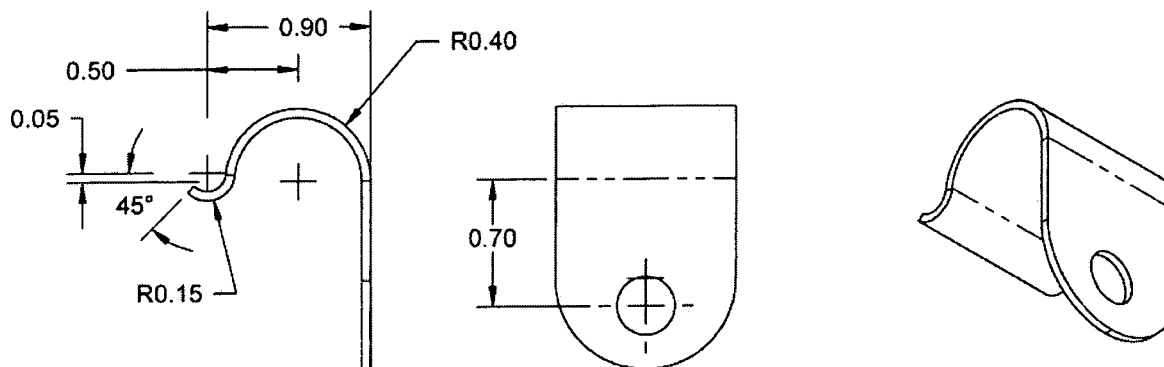
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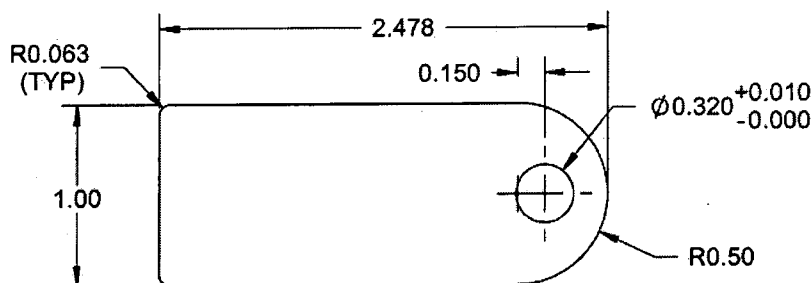
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED

05.08.16 [Signature]



D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S180A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

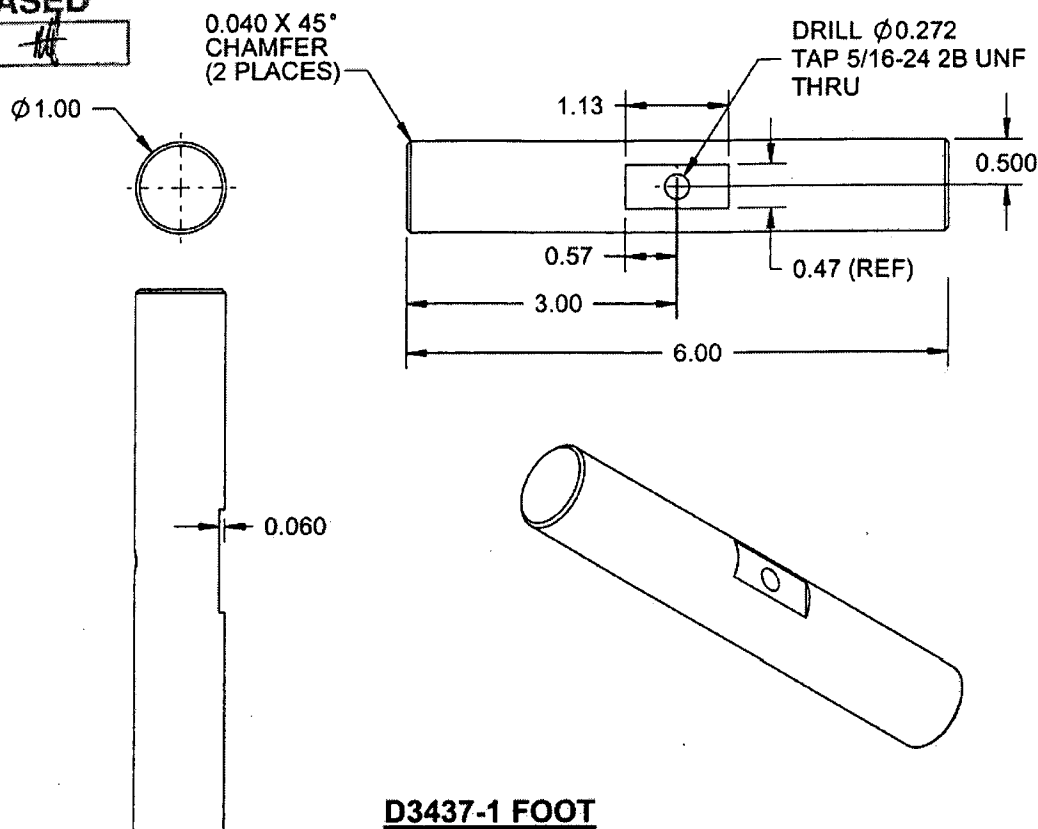
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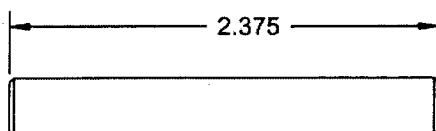
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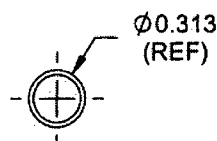
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 3 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

RELEASED05.08.11 *[Signature]***D3437-1 FOOT****D3437-1 FOOT:**

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3437-7 THREADED ROD****D3437-7 THREADED ROD:**

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



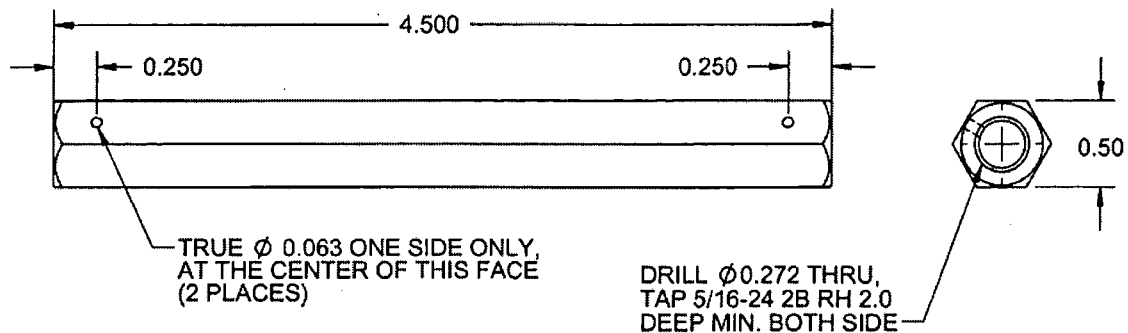
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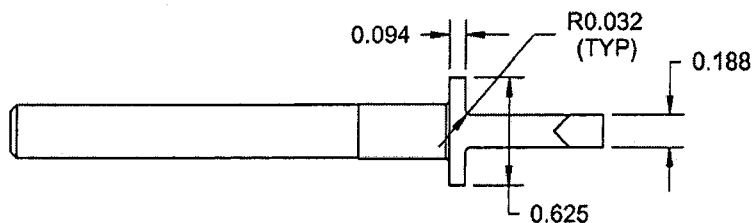
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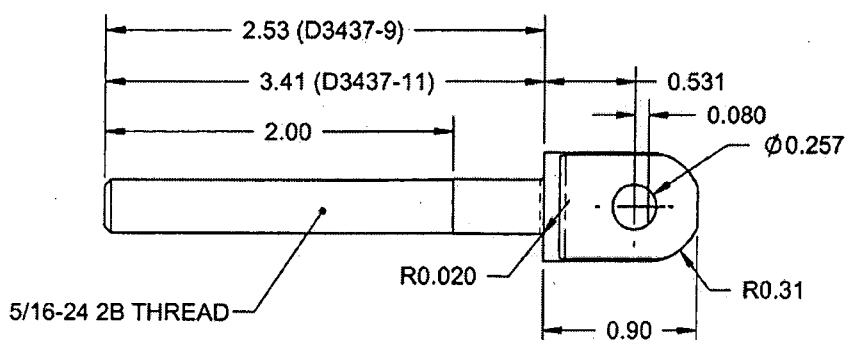
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CHECKED #	APPROVED #	DRAWING NO. D3437	REV. B SHEET 4 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

**D3437-5 STRUT:**

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**

05-08-16

**D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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